

Work Order ID 59111

Wednesday, May 26, 2010 1:23:14 PM



Page 1

Item ID: D2743

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 5/26/2010 Start Qty: 280.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 280.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10526

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2743

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV: *B*DWG REV: *SA 10/06/06*

2-DEBURR AS REQUIRED

394 *SA*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SA 10/06/06**394* *SA*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 5/26/2010 Start Qty: 280.00

Required Date: 6/4/2010 Req'd Qty: 280.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>smr10/06/06</i>		<u>394</u>			
130  Skidtubes Skidtubes	 Memo 1- Clean crossbolt spacer with ultra bright aluminum cleaner	0.00 0.00				<u>394</u>		<u>4 10/6/7</u>	
160  Packaging Packaging	Identify as per dwg & Stock Location: <u><i>cb.</i></u> Memo	0.00 0.00				<u>394</u>		<u>4 10/6/7</u>	

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08 JG

R/ 10-6-08

(394)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 1:23:18 PM

Page 1

Work Order ID: 59111

Parent Item: D2743

Parent Item Name: Crossbolt Spacer

Comments: IPP ☐ E ☐ 05.04.13 ☐ Reformat; removed tumble and deburr step ☐ KJ/JLM ☐

Start Date: 5/26/2010

Required Date: 6/4/2010

Start Qty: 280.00

Required Qty: 280.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	60.7070	0.2667	78.60632			



6061-T6 RD Tube .625 x.065W



Location	Loc Qty	Loc Code
MAT	48	
114585	48	
MAT014	12.707	
110778	1.541	
- 111944	11.166	

M114812

4024

11.186

60 A

5/26/2010

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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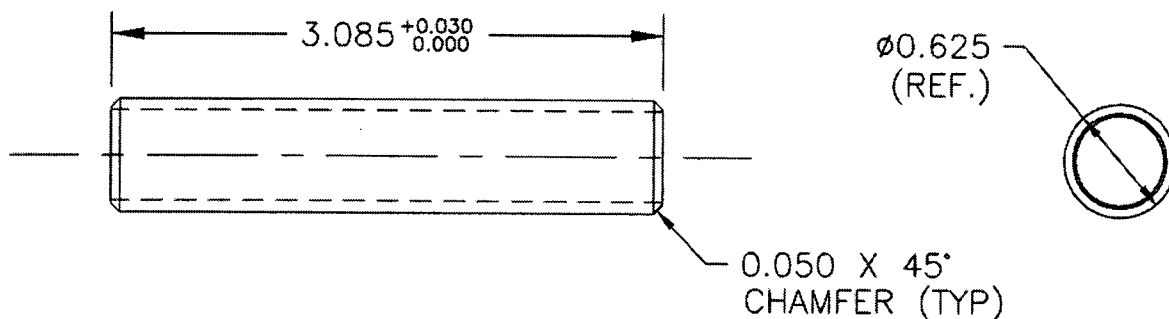
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER SCALE 1:1	
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.2.16 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59111
R/10-5-20



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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